

Work Order ID 62220

Wednesday, September 22, 2010 1:30:22 PM



Page 1

Item ID:	D3414-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Lug Assembly				Stop	
Start Date:	9/23/2010	Start Qty:	6.00			
Required Date:	10/25/2010	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:	<u>mm</u>	Date:	<u>10-9-22</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3414	Rev C								

140

 Large Fab
 Memo
 1- Weld using location Jig DT8484 as per Dwg D3414
 A/R S.S. welding rod Batch: M101744

0.00

0.00

EL 10-9-23 (46)

150

 QC
 Quality Control
 QC9- Inspect visual per QSI004- Fusion Welds
 Memo

0.00

0.00

(6) PD 10.09.23

160

 QC
 Quality Control
 QC5- Inspect part completeness to step on W/O
 Memo

0.00

0.00

(46)

Sub 10/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62220

Wednesday, September 22, 2010 1:30:22 PM



Page 2

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 9/23/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/25/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M115271

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

0.00

0.00

0.00

0.00

BK 10-10-5

= > M 10/10/05

6

6 6

10/10/05 [Signature]

180



QC

Quality Control

QC3- Inspect Part Finish

Memo

190



Packaging

Packaging

Identify as per dwg & Stock Location: 473

Memo

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3414-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug Assembly

Start Date: 9/23/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 10/25/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/06
mf
10-10-06

Picklist Print

Wednesday, September 22, 2010 1:30:21 PM

Page 1

Work Order ID: 62220

Parent Item: D3414-041

Parent Item Name: Lug Assembly



Start Date: 9/23/2010

Required Date: 10/25/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3414-1 Lug Bracket		Manufactured	No				Each	6.0000		6		EL 10-9-22	
----------------------------	--	--------------	----	--	--	--	------	--------	--	---	--	------------	--

Location Loc Qty Loc Code

WA 6
61034 6

D3414-3 Lug		Manufactured	No			140	Each	4.0000	1	6		EL 10-9-22	
--------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	------------	--

Location Loc Qty Loc Code

WA 4
61240 4

61537 x 2

4
2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

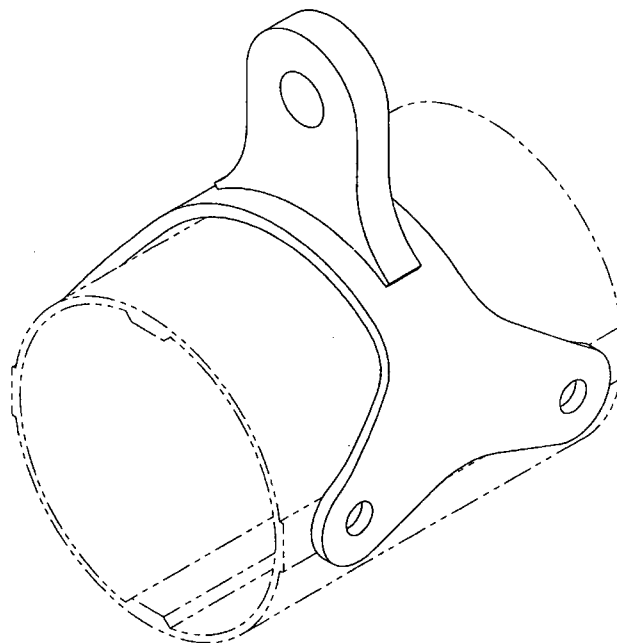
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NOTE: Date & initial all entries

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	CP	D3414	SHEET 1 OF 3
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	LUG ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

62220

RELEASED
8/16/2017

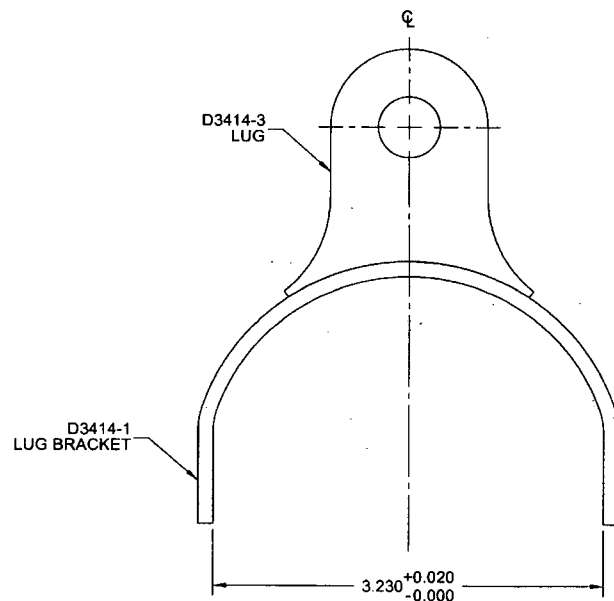
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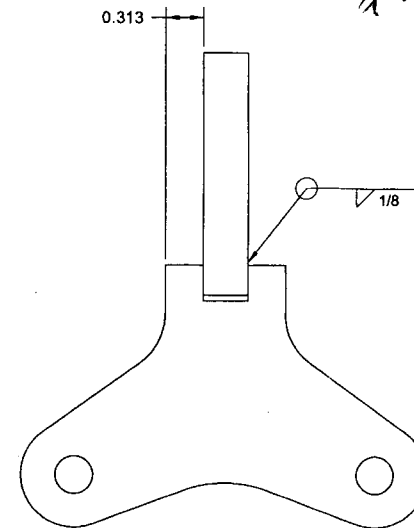
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3414-041 LUG ASSEMBLY



762020

RELEASED

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	CP	DRAWING NO. D3414	REV. C
MFG. APPR.	CP	TITLE LUG ASSEMBLY	SHEET 2 OF 3
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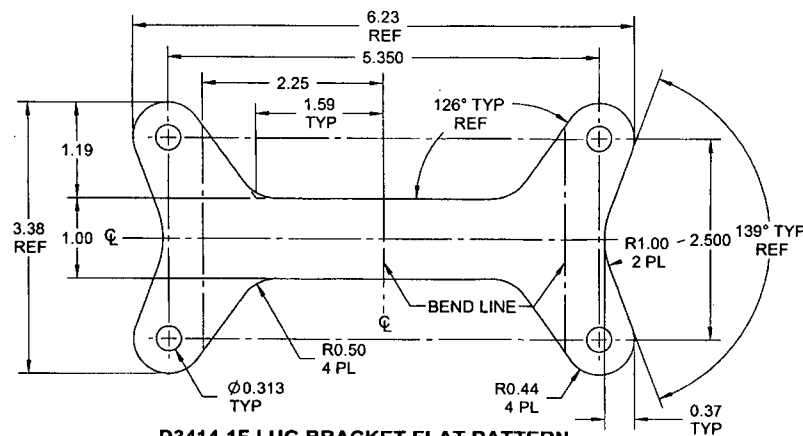
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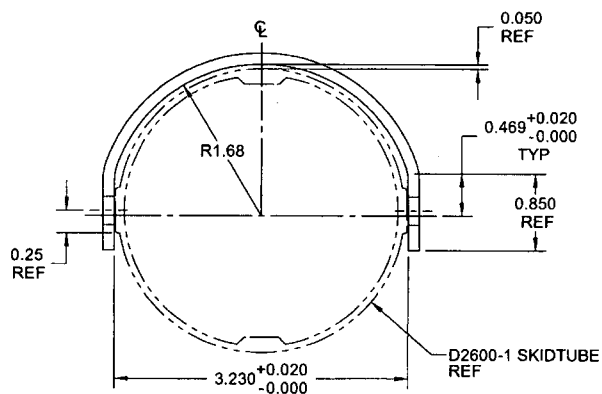
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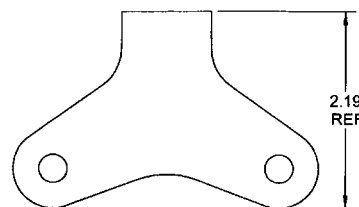
NOTE: Date & initial all entries



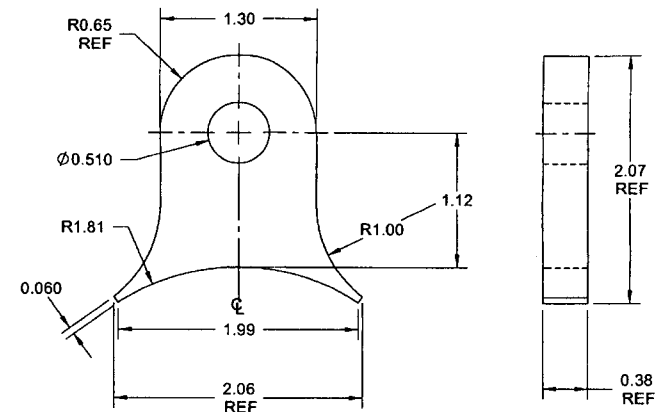
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

NOTES:

- 1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA
- 3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX \triangle
-3: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
09/06/17

DESIGN	QP	DART AEROSPACE LTD	
DRAWN	QP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3414	REV. C
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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